

Date: Monday, 3/19/2007 8:17:25 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 31270A		
Estimate Number	: 10731		
P.O. Number	: N/A	Part Number	: D23243
This Issue	: 3/19/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2324 REV. C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30139A	Drawing Revision	: C
		Material	: N/A
		Due Date	: 4/12/2007
Written By	: _____	Qty:	20
Checked & Approved By	: <u>07.03.19</u>	Um:	Each
Comment	: Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"
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Comment: Qty.: 0.5565 f(s)/Unit Total: 11.1300 f(s)
 6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)
 (M6061T6B0.750x00.750) Batch: 71100742 = 19
117790 = 4 pieces mk 07/03/22

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: (0.75" x 0.75") x 5.75" Long Bar

mk 07/03/22

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio D2324-3 and Dwg D2324
 2- Deburr and Tumble to remove sharp edges
 Identify as D2324-3

mk 07/03/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/03/22

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/28

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS

07-03-26

(28)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

By 3/27 23

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

By 7/3/27 23

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(23)

Comment: FINAL INSPECTION/W/O RELEASE

1207/03/28

Job Completion



U 07-03-28

Dart Aerospace Ltd

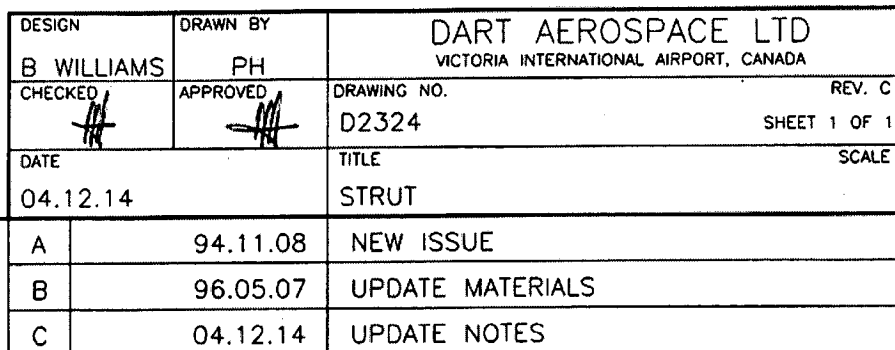
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

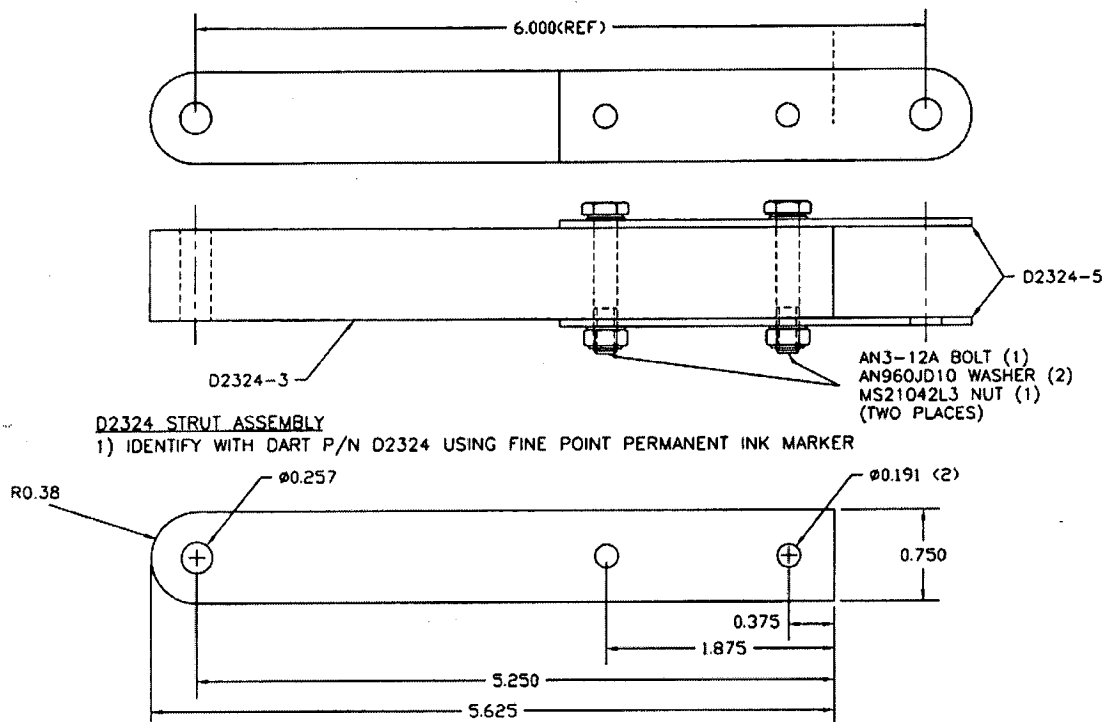
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

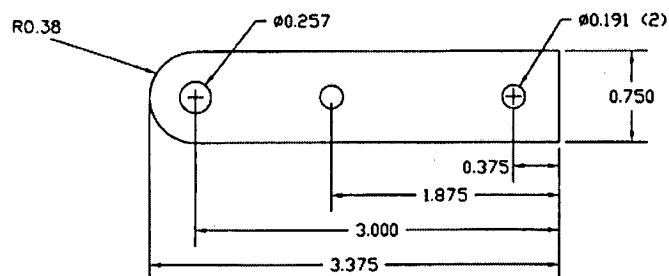


04.12.16



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: --- ACID-ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



02324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31270A